

Work Order ID 133648

Monday, June 15, 2015 1:57:55 PM

133648

Page 1

Item ID: D350-589-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Side Door Latch Modification

Stop ***NS2***

Start Date: 6/15/2015 **Start Qty:** 1.00

1

Cust Item ID:

Required Date: 6/15/2015 **Req'd Qty:** 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ Date: JUN 15 2015 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Stop ***NR2***

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Work Order ID 133648***133648***

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Revision ID:

Stop ***NS2***

Item Name: Side Door Latch Modification

Start Date: 6/15/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/15/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

0.00

120

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per QSI 014
Location :FG022DAS
02
9-89

JUL 27 2015

130

0.00

130

QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

5/17/28 JH
20150728

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Picklist Print

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Work Order ID: 133648

133648

Parent Item: D350-589-011

D350-589-011

Parent Item Name: Side Door Latch Modification

Start Date: 6/15/2015

Required Date: 6/15/2015

Start Qty: 1.00

Required Qty: 1.00

D2586

Manufactured No

105

Each

44.0000

3

3

D2586

Door Latch

DAS
02
9-89

Location

Loc Qty

Loc Code

FG

16

100607

1

114985

5

119746

4

83893

5

95760

1

ST482

28

129404

28

**

JA

DAS
27
9-8

D2587

Manufactured No

105

Each

18.0000

1

1

D2587

Door Plug

DAS
02
9-89

Location

Loc Qty

Loc Code

ST008

18

121824

6

132626

12

**

JA

DAS
27
9-8

D2589

Manufactured No

105

Each

36.0000

1

1

D2589

Keys, Key Chain

DAS
02
9-89

Location

Loc Qty

Loc Code

ST008

36

132942

36

**

JA

JUL 27 2015

DAS
27
9-8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
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Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

Page 3

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Work Order ID: 133648

133648

Parent Item: D350-589-011

D350-589-011

Parent Item Name: Side Door Latch Modification

Start Date: 6/15/2015

Required Date: 6/15/2015

Start Qty: 1.00

Required Qty: 1.00

MS20470AD4-5

Purchased

No

105

Each

1,290.000

6

6

MS20470AD4-5

RIVET, UNIVERSAL HEAD

**DAS
02
9-89**

Location

Loc Qty

Loc Code

GA

1269

m128401

1245

m128813

24

ST310

21

m128813

21

JA

**DAS
27
9-89**

MS21042L3

Purchased

No

105

Each

2,136.000

3

3

MS21042L3

Nut

**DAS
02
9-89**

Location

Loc Qty

Loc Code

FP001

411

M130922

411

GA

483

M131317

483

ST305

1242

116549

12

126333

49

M128754

2

M132123

179

M132382

1000

JA

JUL 27 2015

**DAS
27
9-89**

Monday, June 15, 2015 1:57:59 PM

Shop Packet Print

Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Parent Item: D350-589-011

D350-589-011

Parent Item Name: Side Door Latch Modification

Start Date: 6/15/2015

Required Date: 6/15/2015

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-15

Purchased

No

105

Each

196.0000

3

3

MS27039-1-15

JA

Screw

**DAS
02
9-89**

Location

Loc Qty

Loc Code

GA

77

m127916

77

ST285

119

m127916

16

m130388

3

m132317

100

3

NAS1149D0363J

Purchased

No

105

Each

1,781.000

3

3

NAS1149D0363.J

JA

JUL 27 2015

Washer

**DAS
02
9-89**

Location

Loc Qty

Loc Code

CA

569

m130799

569

GA

182

m128429

182

ST269

1030

m126319

7

m131618

23

m132317

1000

3

DQA: _____ Date: _____



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OTHER : ☐					

3.4 PARTS LIST

589 -011	589 -041	589 -042	589 -043	Part Number	Description
X				D350-589-011	SIDE DOOR LATCH MODIFICATION KIT
	X			D350-589-041	SIDE DOOR ASSEMBLY, LH AS 350
		X		D350-589-042	SIDE DOOR ASSEMBLY, RH AS 350/355
			X	D355-589-043	SIDE DOOR ASSEMBLY, LH AS 355
	1			D2991-1	Door
		1		D2991-2	Door
			1	D2991-3	Door
3	3	3	3	D2237	Striker Plate
	1	1	1	D2464-1700	Seal
3				D2583	Latch Bracket
3	3	3	3	D2585	Latch Clamp
3	3	3	3	D2586	Latch
1				D2587	Plug
1	1	1	1	D2589	Keys, Key Chain
	3	3	3	D2621	Latch Plate
	2**	2**	2**	D2992-1	Doubler
	1	1	1	D3085-041	Prop Assembly
	1*	1*	1*	D3015-3	Locknut
	1*	1*	1*	D3081-1	Prop Hinge
	1*	1*	1*	D3082-1	Clip
	1*	1*	1*	D3084-1	Prop Arm
	1*	1*	1*	AN4-5A	Bolt
	3*	3*	3*	AN960JD10	Washer
	3*	3*	3*	AN960JD10L	Washer
	2*	2*	2*	AN960JD416	Washer
	1*	1*	1*	AN960JD516L	Washer
	3*	3*	3*	MS21042L3	Nut (or MS21042-3)
	1*	1*	1*	MS21042L4	Nut (or MS21042-4)
	3*	3*	3*	MS27039-1-13	Screw
	1*	1*	1*	SL69-BS	Ball Stud
	6	6	6	AN3-4A	Bolt
3	3	3	3	AN960JD10	Washer
3	9	9	9	MS21042L3	Nut (or MS21042-3)
6	6	6	6	MS20470AD4-5	Rivet
3	3	3	3	MS27039-1-15	Screw

* Reference only. Included in D3085-041 Prop Assembly listed above.

** Reference only. Included in D2991-1/-2/-3 Doors listed above.

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Revision: E

Date: 02.02.22

O new stock

Work Order ID 133648

Monday, June 15, 2015 1:57:55 PM

133648

Page 1

Item ID: D350-589-011

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Side Door Latch Modification

Start Date: 6/15/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/15/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ Date: JUN 15 2015 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
INN-D350-589	E								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork Photocopy blue file and type label as per PPP D350-589-011 CHG002									
105	Pick Kit	0.00							
105									
Packaging	Memo	0.00							
Packaging									
110	QC4- 100% Inspect kits for completeness	0.00							
110									
QC	Memo	0.00							
Quality Control									

MLJ JUL 22 2015